

Work Order ID 67778

Wednesday, March 30, 2011 10:38:05 AM



Page 1

Item ID: D3041-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Clamp					
Start Date: 3/30/2011	Start Qty: 40.00		Cust Item ID:		
Required Date: 4/4/2011	Req'd Qty: 40.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3041	Rev C

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D2423 Extrusion: 1.250" Long								

Cut @ meter

CL 11/04/06

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine per folio FA153								

DWG REV: as per drawing D3041 REV.C
FOLIO REV:

CL 11/04/06 (40)

120		0.00							
	QC2 - Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

rec'd + inspect for transit damage.
attached c/c to w/o

CL 4/15 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 4/4/2011 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC6 Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11 04 15 (40)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 40 04 16 10/15

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 11 04 18 (40)

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Page 3

Item ID: D3041-1

Accept



Setup Start



Revision ID:

Item Name: Clamp

Stop



Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 116964.

Memo

0.00

Powder Coating

Mask inside of 0.8120" diameter hole ☐ START TIME:
1.55 ☐ OVEN TEMPERATURE: *320°* ☐ FINISH
TIME: *2.25.*

40

11-4-18.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

40

4/4/18

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D3041 ☐ 2- Stake bearing into place
as per Dwg D3041 ☐ **PLEASE SEE JASON BEFORE PRESSING ☐
BEARINGS FOR NEW TOOLING **

4/5/11/04/20 *(40)*

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Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

0.00 *Sub 121*

QC

Memo

Quality Control

200

Identify as per dwg & Stock Location: *463*

0.00



0.00

Packaging

Memo

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

Count
*40**11/4/25* *sf* *40**11/4/25**mf**11-04-25*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 11:15:15 AM

Page 1

Work Order ID: 67778

Parent Item: D3041-1

Parent Item Name: Clamp



Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: as per revC1 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2611 Bearing		Manufactured	No			100	Each	20.0000	1	40			
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Location	Loc Qty	Loc Code
ST018	20	
65640	20	

D2423 Lug Extrusion		Manufactured	No			180	f	384.5000	0.0833	3.507368			
----------------------------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--

Location	Loc Qty	Loc Code
MAT006	384.5	
43722	161.5	
45800	1	
63005	222	

D3041-1P

X40

Handwritten notes and signatures:
 4/5/11/04/20
 B68085 (200)
 20
 11.01.26
 4/4/11

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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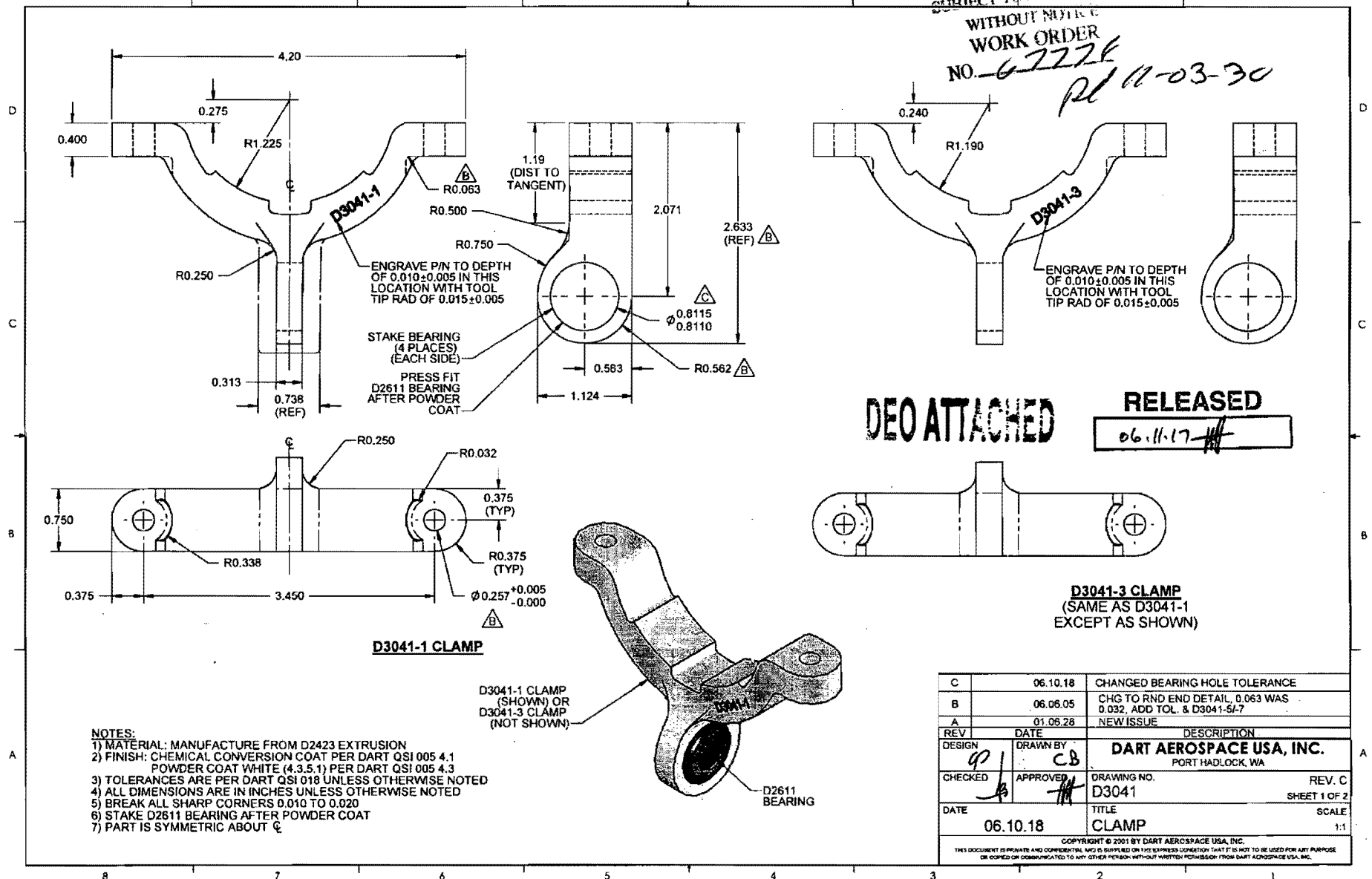
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NOTE: Date & initial all entries

SHOWING
REVISIONS
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 67276
Pl 11-03-30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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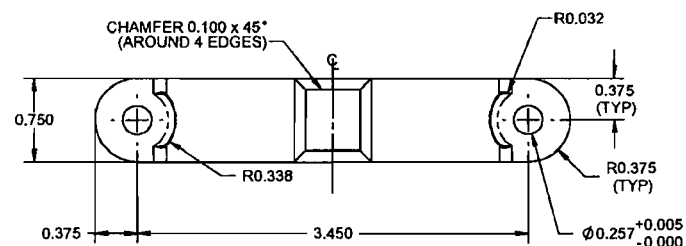
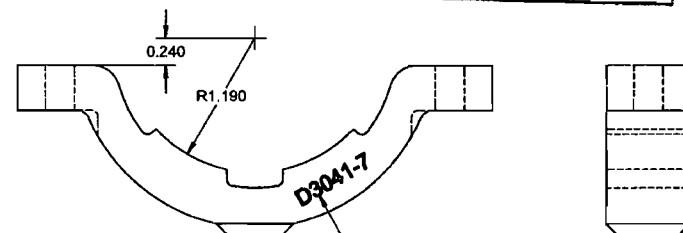
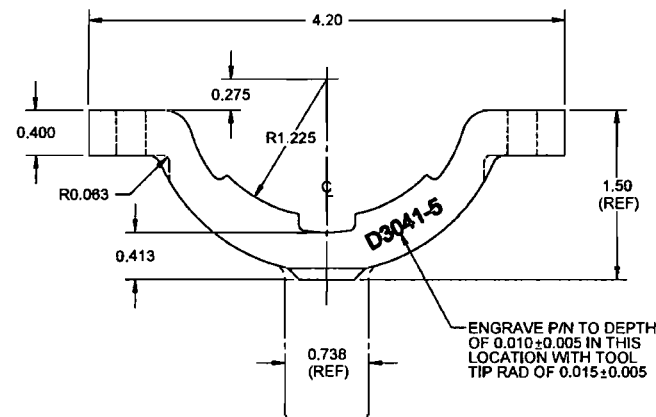
NOTE: Date & initial all entries

W/O 67778

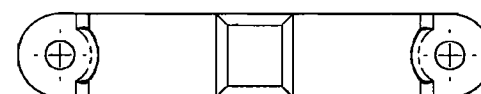
DEO ATTACHE

RELEASED

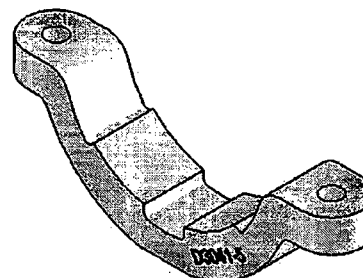
06.11.17



D3041-5 CLAMP



D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)



NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA	
DATE	DRAWING NO.	REV. C	
06.10.18	D3041	SHEET 2 OF 2	
TITLE		SCALE	
CLAMP		1:1	
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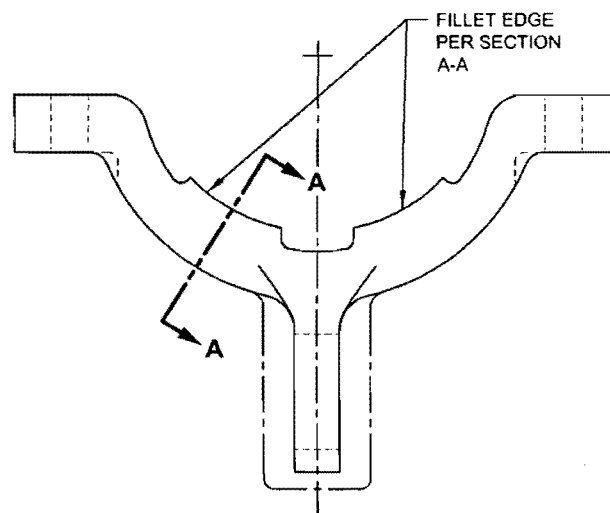
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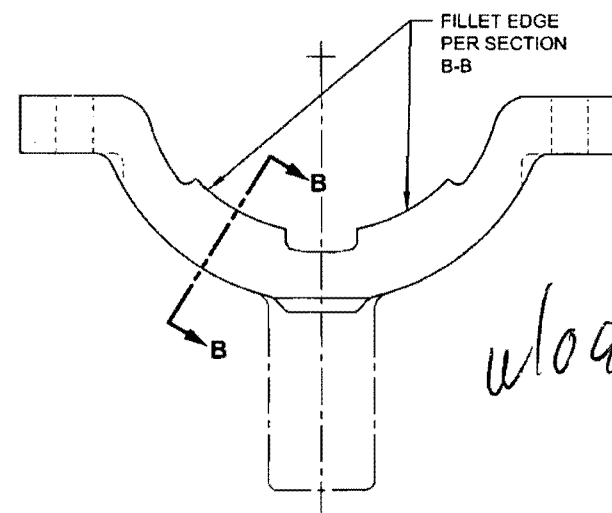
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP

wlog7778



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13814**

Purchase Order Date 4/6/2011
PO Print Date 4/6/2011

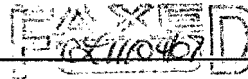
Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

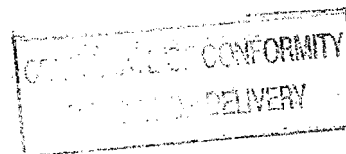
Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-1P	Clamp	4/15/2011 Yes	40.00 Each	Dart Truck	\$31.0000	\$1,240.00

Special Inst: AS PER DWG D3041 REV. C
B67778

PO Total: \$1,240.00



Change Nbr: 1

Change Date: 4/6/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17903
Date: Apr 13, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13814	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp Material supplied by DART: D2423 B63005	Each		40	
Received by _____	Thank you for your order!			



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D3041-1	Clamp	13814

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, April 13, 2011

